

# Work Order ID 82783

**\*82783\***

Page 1

April-10-12 7:17:07 AM

Item ID: D3700-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Inboard Window Doubler

Start Date: 4/10/12 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 4/10/12 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3700

Rev B

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3700 Dwg Rev: B Prog Rev: B 2-  
Deburr if necessary

6061 0.080

(4)

*M/J* Jan-  
12-4-10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

(4)

*M/J* Jan-  
12-4-10

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

(4)

*Sunday*

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Page 2

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

HandFinish

Memo

0.00

Hand Finishing

4. 6 BL 12-4-12

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Memo

0.00

Quality Control

4x 0 m/L 12/04/12

150

Identify as per dwg & Stock Location: 060

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

4 12/3/12

**Work Order ID 82783****\*82783\***

Page 3

April-10-12 7:17:07 AM

Item ID: D3700-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Inboard Window Doubler

Start Date: 4/10/12 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 4/10/12 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

12/4/12 JG

12-04-12

# Picklist Print

April-10-12 7:17:06 AM

Page 1

Work Order ID: 82783

Parent Item: D3700-1

Parent Item Name: Inboard Window Doubler

Start Date: 4/10/12

Required Date: 4/10/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-01-30 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No				sf	580.3200		1.1605803			
6061-T6 .080 Sheet													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	580.32	
117285	2.15	
119766	39.77	
120096	335	
120349	11.4	
121193	192	

120096

Jm-  
12-4-10

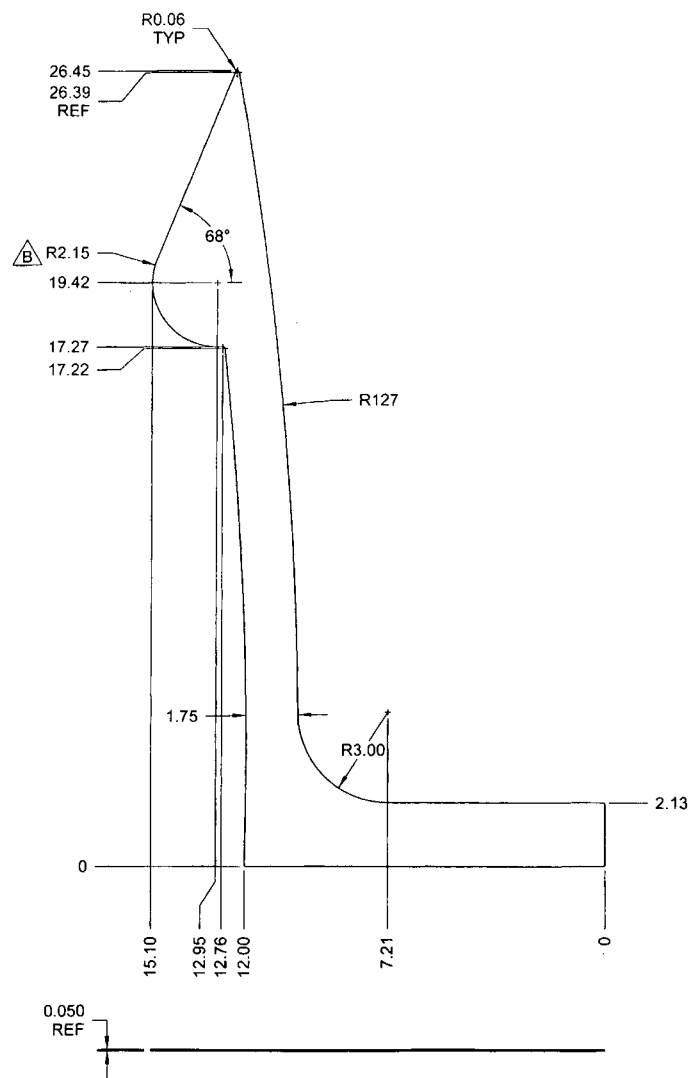


**D3700-1 INBOARD WINDOW DOUBLER**

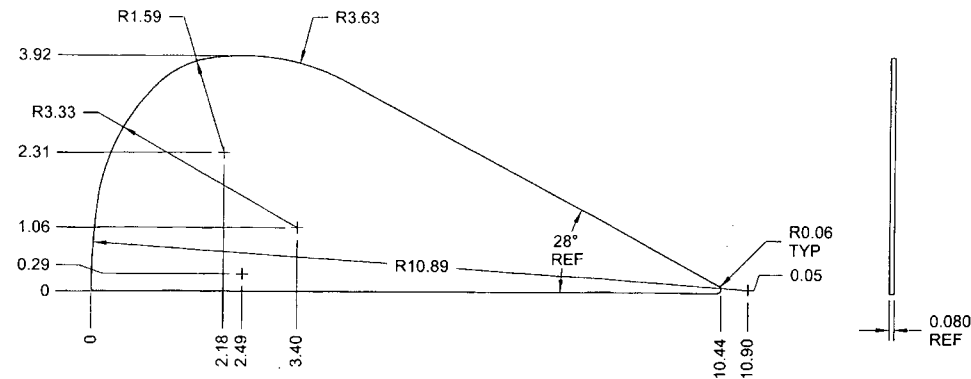
**D3700-3 OUTBOARD WINDOW DOUBLER**

**RELEASED**  
09/21/18

REV.	DESCRIPTION	BY	DATE
B	ADDED 0.25" TO TOP PROFILE OF D3700-1 (ZN D8-2). REDIMENSION PARTS; REMOVED REFERENCES TO DXF FILES (NOTES 8 AND 9).	MB	09.03.18
A	NEW ISSUE	MB	08.01.29
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3700</b> REV. B SHEET 1 OF 2 TITLE <b>WINDOW DOUBLER</b> SCALE NTS DATE <b>09.03.18</b> <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			



**D3700-3 OUTBOARD WINDOW DOUBLER**



**D3700-1 INBOARD WINDOW DOUBLER**

**RELEASED**

**NOTES:**

- 1) MATERIAL:  
D3700-1: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)  
D3700-3: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3700-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3700-1 = 0.20 lbs  
D3700-3 = 0.37 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.		D3700	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WINDOW DOUBLER	NTS
DATE	09.03.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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